



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D117-762-041
Job Sheet 171456



Part No: D117-762-041

Job Qty: 1 ea

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV.C (ecn16-514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials



Container No: S044367



Part: D117 - 762 - 041

Job No: 171456

Serial No/Batch: S044367

Revision: D3582 PRELIM.

Inspector:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
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Date: 02/21/18

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		2/16/18	0.00	0.00	Start Up Skidtubes-1	
130	Skidtubes	1 pcs		2/16/18	0.00	3.47	Skidtubes-1	
140	Skidtubes	1 pcs		2/17/18	0.00	3.47	Skidtubes-1	
150	QC	1 pcs		2/17/18	0.00	0.00	QC10	
160	QC	1 pcs		2/17/18	0.00	0.00	QC5	
170	HandFinish	1 pcs		2/17/18	0.00	0.97	HandFinish1	
180	QC	1 pcs		2/17/18	0.00	0.00	QC7-1	
190	Skidtubes	1 pcs		2/17/18	0.00	3.47	Skidtubes-1	
200	QC	1 pcs		2/17/18	0.00	0.00	QC10	
210	QC	1 pcs		2/17/18	0.00	0.00	QC5	
215	HandFinish	1 pcs		2/17/18	0.00	0.97	HandFinish2	
220	Powdercoat	1 pcs		2/17/18	0.00	0.26	Powdercoat1	
230	QC	1 pcs		2/17/18	0.00	0.00	QC3	
250	HandFinish	1 pcs		2/19/18	0.00	0.97	HandFinish4	
260	QC	1 pcs		2/19/18	0.00	0.00	QC5	
265	DC	1 pcs		2/19/18	0.00	0.00	DC	
270	Packaging	1 pcs		2/19/18	0.00	0.00	Packaging3-1	
280	QC21-FG	1 Ea		2/19/18	0.00	0.00	QC21	

Part Op 130 - 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN AFT CAP HOLE TO .187" Descriptions: *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16 cleco in Ground wire hole

, then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine on D5520-1 doublers. 11-open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill. 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open holes of section G-G to finishes size.

140 - 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: M138673 2-Grind flush

190 - ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E and G-G, ***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sika Flex Batch: M138787 Exp Date: APR 21 2018 6- Swage x-bolt spacer as per dwg and Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD Batch: 41M136158 8-Grind welds flush

215 - Touch-up alodine as per QSI

220 - START TIME 11:55 OVEN TEMPERATURE: 320° FINISH TIME: 1:55 M138467

250 - 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex

Batch: _____ Exp Date: _____ 3-Install Wearplates as per Dwg D3582 , Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

265 - Photocopy bluefile & type labels per PPP D117-762-041 CHG003

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 Ea (1 ea)	90-Start up Operation	5042815
D5520-1	Doubler	2 Ea (2 ea)	130-Skidtubes	5004478
D2964	Cap	1 Ea (1 ea)	140-Skidtubes	F163672
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes	5013777
D2971	Cross Bolt Spacer	1 Ea (1 ea)	190-Skidtubes	F135918
D3584-1	Web	1 Ea (1 ea)	190-Skidtubes	6008618
D3662-1	Crossbolt Spacer	3 Ea (3 ea)	190-Skidtubes	F1634413
D3662-3	Crossbolt Spacer	1 Ea (1 ea)	190-Skidtubes	F161006
D5304-1	Crossbolt Spacer	2 Ea (2 ea)	190-Skidtubes	5014375
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-HandFinish	5008959
ALS4-428-165	Insert	2 Ea (2 ea)	250-HandFinish	FN1137054-0
AN3C4A	Bolt	28 Ea (28 ea)	250-HandFinish	5019394
AN4-4A	Bolt	2 Ea (2 ea)	250-HandFinish	5044215
D2965	Cap	1 Ea (1 ea)	250-HandFinish	5003576
D3508-11	Wearplate Aft Center	1 Ea (1 ea)	250-HandFinish	5007509
D3508-13	Wearplate Aft	1 Ea (1 ea)	250-HandFinish	5019452
D3508-3	Wearplate Fwd Center	1 Ea (1 ea)	250-HandFinish	F16378
D3508-9	Wearplate Fwd	1 Ea (1 ea)	250-HandFinish	5021464
D3558-11	Gasket Aft Center	1 Ea (1 ea)	250-HandFinish	5023350
D3558-13	Gasket Aft	1 Ea (1 ea)	250-HandFinish	5023241
D3558-3	Gasket Center Fwd	1 Ea (1 ea)	250-HandFinish	5046190
D3558-9	Gasket Fwd	1 Ea (1 ea)	250-HandFinish	5023796
NAS1149C0332R	Washer	28 Ea (28 ea)	250-HandFinish	5019380
NAS1149D0332J	Washer	2 Ea (2 ea)	250-HandFinish	5020606
NAS1149D0416J	Washer	2 Ea (2 ea)	250-HandFinish	FN1131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3582-1-BENT	1	0	0
130-Skidtubes	D5520-1	2	16	0
140-Skidtubes	D2964	1	5	0
190-Skidtubes	CR3212-5-05	68	507	0
	D2971	1	13	0
	D3584-1	1	7	0
	D3662-1	3	17	0
	D3662-3	1	44	0
	D5304-1	2	35	0
250-HandFinish	ALS4-1032-130	36	8,837	0
	ALS4-428-165	2	25	0
	AN3C4A	28	1,994	0
	AN4-4A	2	32	0
	D2965	1	0	0
	D3508-11	1	11	0
	D3508-13	1	3	0
	D3508-3	1	10	0
	D3508-9	1	9	0
	D3558-11	1	6	0
	D3558-13	1	6	0
	D3558-3	1	1	0
	D3558-9	1	6	0
	NAS1149C0332R	28	2,877	0
	NAS1149D0332J	2	4,270	0
	NAS1149D0416J	2	3,346	0

Part Specifications

Specifications could not be found.

Plex 2/1/18 11:57 AM Dart.Gagnon.Michelle

001248

ITEM	Qty -041	Part Number	Description
	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2962-150	EXTRUSION
2	1	D2964	CAP
3	1	D2965	CAP
4	1	D2971	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3882-1	CROSS BOLT SPACER
15	1	D3882-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1149C0332R	WASHER (AN960C10L)
22	2	NAS1149D0332J	WASHER (AN960JD10L)
23	2	NAS1149D0416J	WASHER (AN960JD416L)
24	36	AELS-1032-130	INSERT
25	2	AL87-428-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

NOTES:

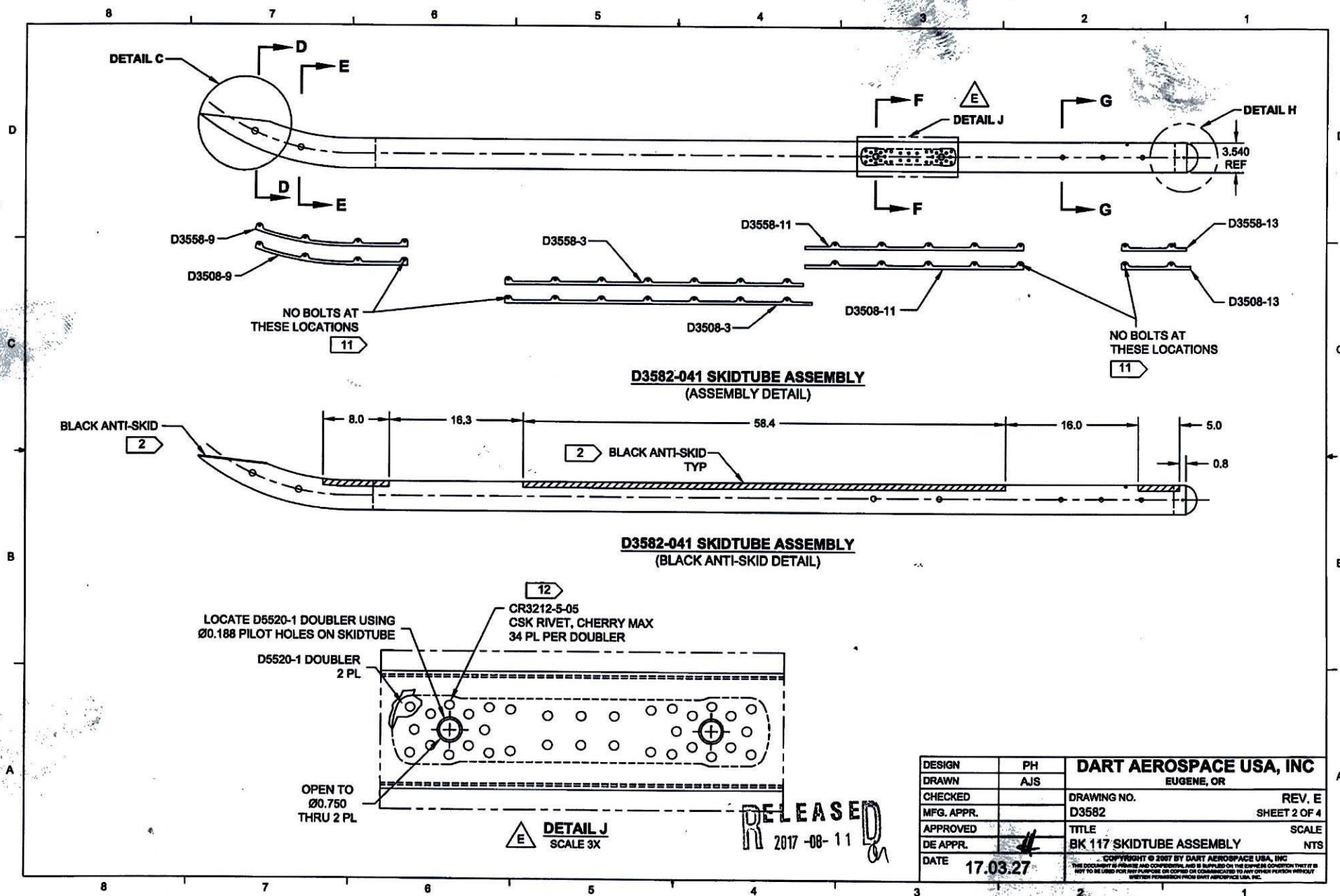
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18.2 lbs
- 8) WELDING: PER DART QSI 004.
- 9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 10) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS IN INDICATED LOCATIONS
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309. COUNTERSINK Ø0.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

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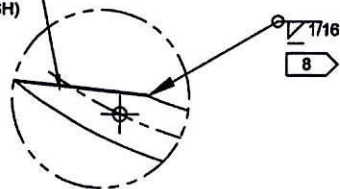
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2017-08-11
KEN 17-547

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.187 HOLE WAS Ø0.75. ADD SHT 3, ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D5304-1 WAS D2973; REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A8-3); REF NCR16-6160	RF	17.01.09
C	D3492 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	29.86 WAS 29.87 (ZN C2-1), INCORPORATED DEO D3582-A-1 (ZN D5-1), FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3582	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.	#	BK 117 SKIDTUBE ASSEMBLY	NTS
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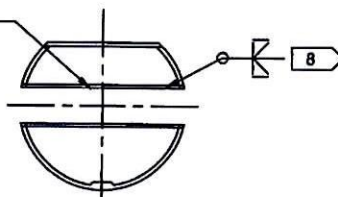
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MFG. APPR.		D3582	SHEET 2 OF 4
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DE APPR.		BK 117 SKIDTUBE ASSEMBLY	NTS
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D2964 CAP
(GRIND FLUSH)



DETAIL C
SCALE 4X

D2971 SPACER



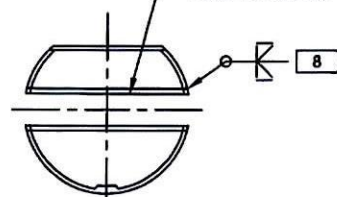
SECTION D-D
SCALE 4X

SECTION D-D NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2971 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER

D3662-3 SPACER



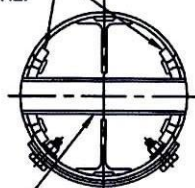
SECTION E-E
SCALE 4X

SECTION E-E NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER

D5520-1 DOUBLER
REF



D5304-1 SPACER
2 PL

SECTION F-F
SCALE 4X
2 PL

SECTION F-F NOTES

AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:

1. INSERT D5304-1 SPACER
2. SWAGE TO Ø0.565 +0.005/-0.000 X 1.0
DEEP PER QSI 002
3. OPEN THRU HOLE TO Ø0.625
4. GRIND FLUSH

D3584-1 WEB
REF

D3662-1 SPACER
3 PL

10 AFTER FINISH, INSTALL
AELS-1032-130
INSERT 36 PL

AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
28 PL

10

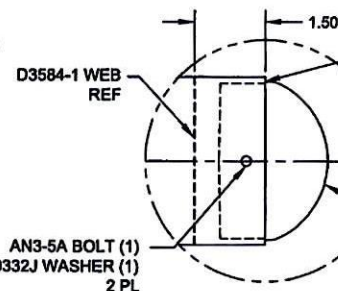
SECTION G-G
SCALE 4X

SECTION G-G NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER

AFTER FINISH, INSTALL
ALS7-428-165 INSERT (1)
AN4-4A BOLT (1)
NAS1149D0416J WASHER (1)
2 PL



AN3-5A BOLT (1)
NAS1149D0332J WASHER (1)
2 PL

DETAIL H
SCALE 4X

SEAL WITH
SIKAFLEX -241/-291

D2965 CAP

RELEASED
2017-08-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3582	SHEET 3 OF 4
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DE APPR.		BK 117 SKIDTUBE ASSEMBLY	NTS
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